

Work Order ID 83773

April-25-12 10:12:45 AM

83773

Page 1

Item ID: D350-591-311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long LH

Start Date: 25/04/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *12/04/26* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

**6 SP*

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

(DAS 16 9-9)

alutro

12-7-19

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/RAluminum Rod

119785
120834

3-Grind End Plate flush

5

9

12-05-16
12-07-05

12.07.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120						5	0		
QC	Memo	0.00							
Quality Control									BE 12/07/12
130	QC5- Inspect part completeness to step on W/O	0.00							
130						5			
QC	Memo	0.00							
Quality Control									12/07/12
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						5X			
HandFinish	Memo	0.00							
Hand Finishing						LH			12/07/12

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

QC7

Memo

0.00

Quality Control

5 127-12

180

0.00

180

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/RAluminum Rod 120854

6-Grind End Plate flush

7-Install last rivet as per Dwg.

5 12.07.16
12.07.16

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5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		12/4/12					
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		12/3/12		45			
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				5	76	12-7-12	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

220

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

230

Wing Walk as per dwg QSI005 4.4 Batch N111505

0.00

230

HandFinish

Hand Finishing

Memo

0.00

240

QC3- Inspect Part Finish

0.00

240

QC

Quality Control

Memo

0.00

5X0

MF
12/07/17

5x11 & 12/07/17

5 LA

12-7-18

M121841

10:45
3200F
11:15

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Pian Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

250

Packaging Memo

Packaging

5x 12-7-19

260	QC4- 100% Inspect kits for completeness	0.00							
-----	---	------	--	--	--	--	--	--	--

260

QC Memo

Quality Control

DAS 16 12/4/20

45 4

270	Packaging	0.00							
-----	-----------	------	--	--	--	--	--	--	--

270

Packaging Memo

Packaging Identify and pack for shipping as per PPPD350-591-311

Location: SHIP

12/7/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 5.00

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____ Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

12/7/24

MCS 12/07/23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 83773

83773

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified

by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1		Manufactured	No			110	Each	20.0000	1	5			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3272-1

Step

**

Ac

12.07.05
12.05.05

Location	Loc Qty	Loc Code
----------	---------	----------

ST	384812	-10
WA	83777	30
	81312	10
	81313	10

10.5

D3067-1		Manufactured	No			110	Each	187.0000	1	5			
---------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

D3067-1

End Plate

**

12.07.05
12.05.05

Location	Loc Qty	Loc Code
----------	---------	----------

WA	B 83855	123
	78608	4
	80881	45
	81969	74
WA016		64
	67582	2
	68214	1
	79607	1
	83053	60

5

12.5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 5.00

Required Qty: 5.00

D3219-1 Manufactured No

110 Each 323.0000 2 10

D3219-1

Plate

**

12-05-15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	84	
82221	84	
WA016	118	
73410	12	
77674	6	
81292	80	
82059	20	
WA017	121	
<u>81971</u>	121	

D3066-1 Manufactured No

180 Each 101.0000 2 10

D3066-1

Spacer

**

B83854 (x10) Ae 12.07.16

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	101	
81968	101	

MS20600-AD4W4 Purchased No

180 Each 3,044.000 16 80

MS20600-AD4W4

Rivets

**

M121652 (80) Ae 12.07.16

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST321	3044	
121011	9	
121340	1035	
121444	2000	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 83773

83773

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 5.00

Required Qty: 5.00

D3065-041

Manufactured No

180 Each

19.0000 1 5

D3065-041

Step Leg Assembly Hi

**

B83871 x4 Ae
B83870 x1 12.07.16

Location

Loc Qty

Loc Code

WA

19

66149

0

78798

18

79336

1

D3067-1

Manufactured No

180 Each

187.0000 1 5

D3067-1

End Plate

**

12.07.16

Location

Loc Qty

Loc Code

WA

123

78608

4

80881

45

81969

74

WA016

64

67582

2

68214

1

79607

1

83053

60

AN3-35A

Purchased No

250 Each

127.0000 10

AN3-35A

Bolt

**

12/6/52
m 118-451 sp
12-7-19

Location

Loc Qty

Loc Code

ST353

127

120644

50

120717

50

121068

27

April-25-12 10:12:49 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 5.00

Required Qty: 5.00

D3235-1 Manufactured No

250 Each

39.0000

D3235-1

Mounting Lug

**

10

B83311 SP

Location

Loc Qty

Loc Code

ST

39

78787

39

D3278-041 Manufactured No

250 Each

68.0000

D3278-041

Support Assembly

**

5

B83856 SP

Location

Loc Qty

Loc Code

ST471

3

78795

3

ST481

65

82015

40

83361

25

AN960JD416 NAS1149D0463J Purchased No

250 Each

10.0000

AN960JD416

Washer

**

80

M122441 SP

Location

Loc Qty

Loc Code

ST351

10

116289

10

AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000

AN960JD516

Washer

**

20

M119546 SP
12-7-19

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Dart Aerospace Ltd

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Parent Item Name: Heli-Access-Step, Long LH

83773

D350-591-311

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 5.00

Required Qty: 5.00

AN5-36A

Purchased

No

250

Each

156.0000

2

10

AN5-36A

Bolt

**

m 121652 SP

Location

Loc Qty

Loc Code

340

100

121181

100

ST340

56

120187

6

120731

50

D2618

Manufactured

No

250

Each

190.0000

2

10

D2618

Bushing

**

1X 8364 SP
9X 84646

Location

Loc Qty

Loc Code

ST012

190

76130

2

80474

188

D2230-3

Manufactured

No

250

Each

87.0000

4

20

D2230-3

Lug

**

B 84133 SP
12-7-19.

Location

Loc Qty

Loc Code

ST480

87

53881

4

70973

1

81558

82

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

83773

D350-591-311

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 5.00

Required Qty: 5.00

D2856-400

Manufactured No

250 f

335.5345 1.2 6

D2856-400

Abrasion Strip

**

SP

W

Location

Loc Qty

Loc Code

ST403	216	
81875	216	
ST409	119.5345	
63735	0.6696	
68076	0.3149	
71164	8.46	
79551	110.09	

6x

*** cut on 7/20/12 (D2856-400-720) ***

MS21042L3

Purchased No

250 Each

3,434.000

2

10

MS21042L3

Nut

**

SP 12-7-19. C

Location

Loc Qty

Loc Code

ST300	3434	
117441	16	
117885	32	
118451	5	
118927	3	
119017	1340	
119075	158	
121349	880	
121444	1000	

10x

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Shop Packet Print

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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 5.00

Required Qty: 5.00

AN4-13A Purchased

No

250

Each

979.0000

8

40

AN4-13A

Bolt

**

M12/652 SP

Location

Loc Qty

Loc Code

ST357

979

119449

39

120187

19

120422

21

120770

400

121162

500

MS21042L5 Purchased

No

250

Each

1,307.000

2

10

MS21042L5

Nut

**

SP

Location

Loc Qty

Loc Code

ST300

1307

116105

5

116548

43

117611

30

119109

1229

MS21042L4 Purchased

No

250

Each

5,814.000

8

40

MS21042L4

Nut

**

SP

Location

Loc Qty

Loc Code

ST300

5814

116188

5

119017

4

119075

805

121011

2000

121444

3000

AN960JD10 NAS1149D0363J Purchased

No

250

Each

0.0000

4

20

AN960JD10

Washer

**

M12/524 SP
12-7-19

April-25-12 10:12:49 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 9P	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07 06 04 **H**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

12/04/26
NO. 83773 MCL
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

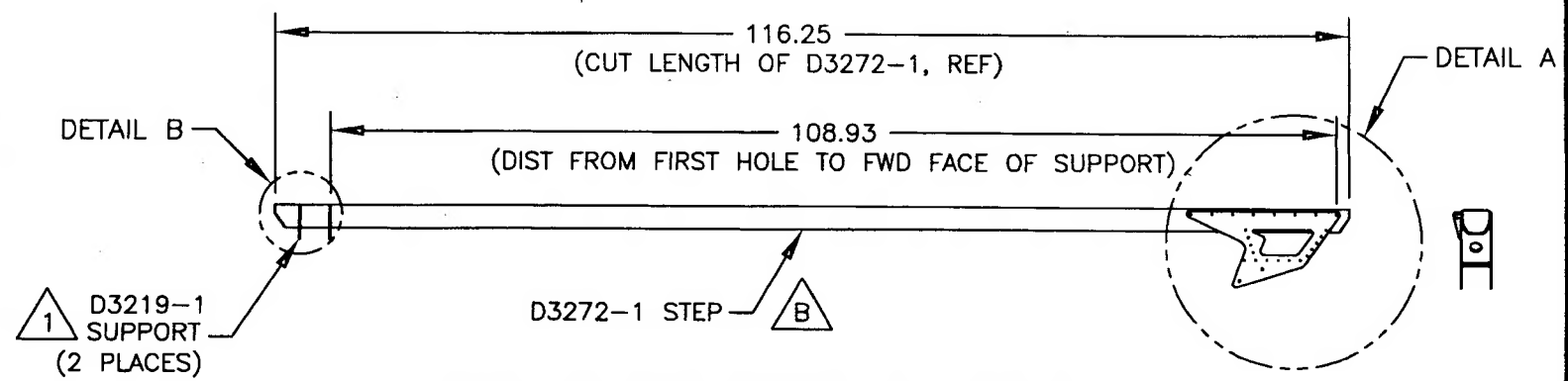
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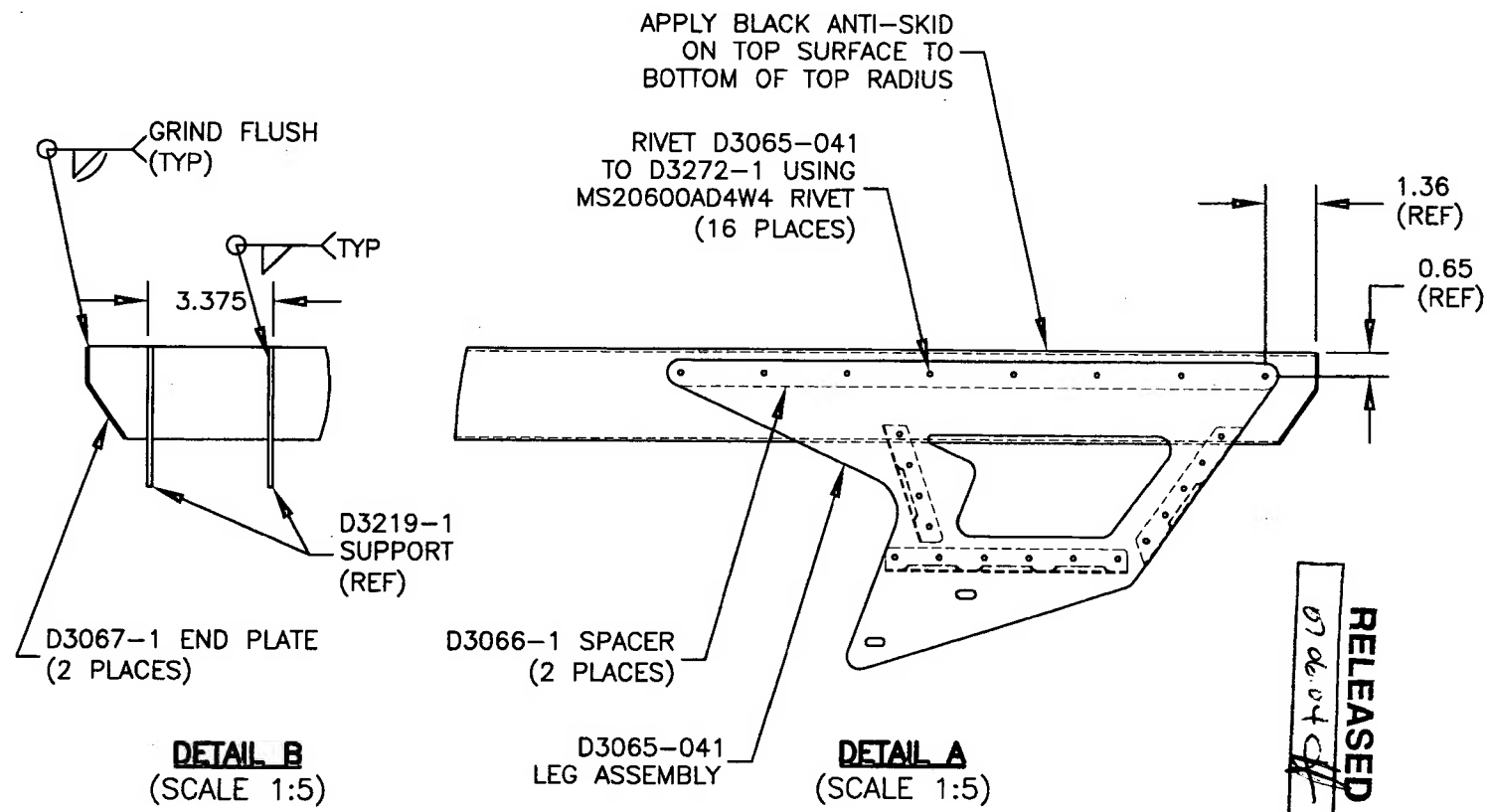
83773



DESIGN 90	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	REV. B
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07.06.04

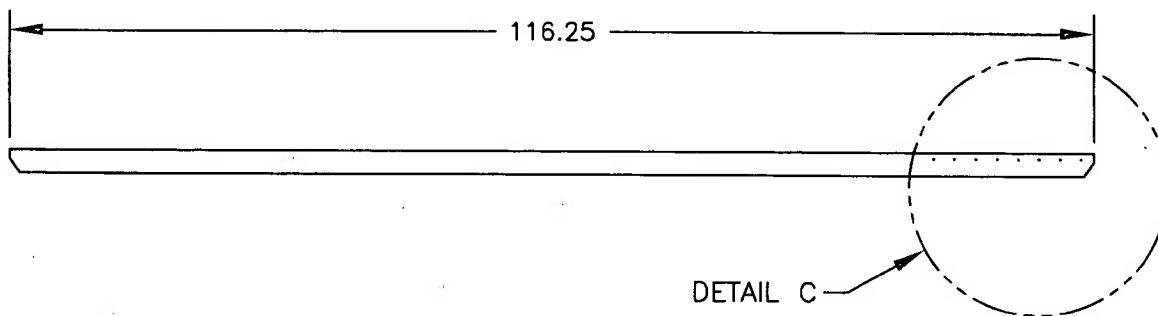
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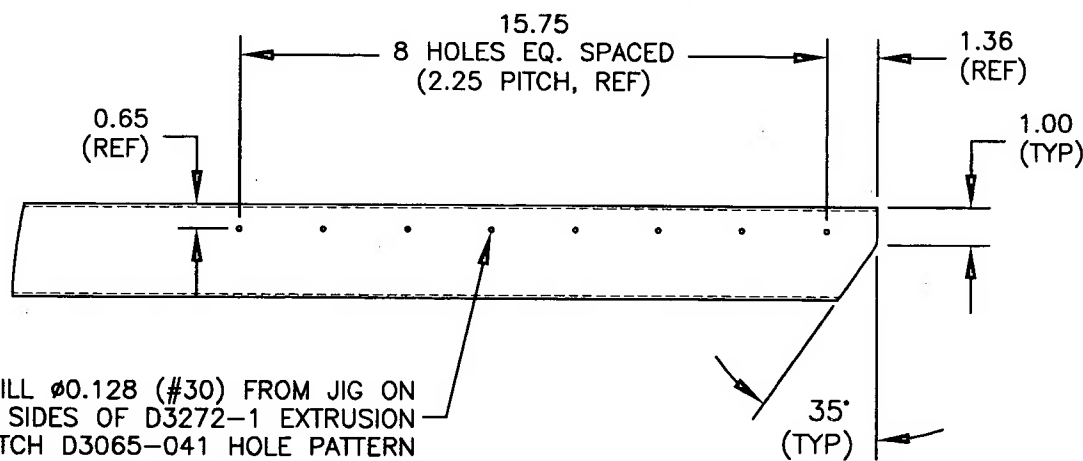


DESIGN	90	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JR	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B
		DRAWING NO.	D3272	SHEET 3 OF 3
		SCALE	1:20	



DETAIL C

B **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED

07.06.04

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.